

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018754**Date Inspected:** 20-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between side Plate to edge Plate for OBG segment 11AW counter weight side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA079-005

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between side Plate to edge Plate for OBG segment 11BW counter weight side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

The Weld Designation is as follows

CA083-001

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between deck Plate to edge Plate for OBG segment 11AW counter weight side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA079-006

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between deck Plate to edge Plate for OBG segment 11BW counter weight side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA083-002

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between side Plate to bottom Plate for OBG segment 11BW Crossbeam side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG067A-021

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between side Plate to bottom Plate for OBG segment 11AW Crossbeam side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

The Weld Designation is as follows

SEG065A-012

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between deck Plate to deck Plate for OBG segment 11AE to 11BE side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBE11-002

Ultrasonic Testing (UT) for Segment 10AW

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG segment 10AW weld joints.

The welds designation reviewed are as follows:

SSD025-PP87-007,011,077,113,131,147,151,155,159

Magnetic Particle Testing (MPT) for OBG CB16

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG crossbeam CB16 weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

CB202A-016-002,008

SP202-005-009,010

SP205-005-009,010

FB204-049-051,052,056

FB204-050-051,052,055,056

FB204-051-051,052,055,056

FB204-052-051,052,055,056

CB202G-049-146,164,145,163,117,118,031,032,142,160,091,092,143,161

CB202G-050-146,164,145,163,117,118,031,032,142,160,091,092,143,161

CB202G-051-146,164,145,163,117,118,031,032,142,160,091,092,143,161

CB202G-052-146,164,145,163,117,118,031,032,142,160,091,092,143,161

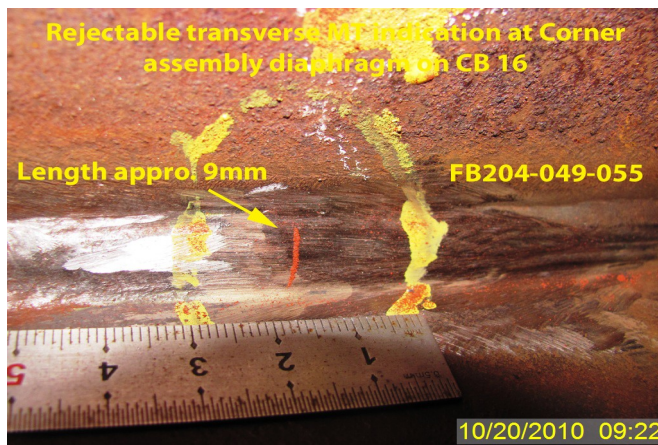
WELDING INSPECTION REPORT

(Continued Page 4 of 4)

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Cross Beam CB16, this Quality Assurance Inspector (QA) discovered the following issues that One Transverse Linear indication measuring approximately 9mm. The weld is identified as FB204-049-55. The weld is the fillet weld joining flange to floor beam diaphragm web plate. Y location is approximately 250mm from east side cope hole. OBG Cross Beam CB16 is located near the North end of bay 19. The Notice of Witness Inspection Number (NWIT) is 07010. Weld FB204-049-55 is within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform 10% MT of this weld.

This QA inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
